

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024993**Date Inspected:** 17-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lei/Wen/Shigang/Feng /Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 9

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 006 located on BK13-001. Welder is identified as 062265. ZPMC Quality Control (QC) is identified as Liu Fawen. The welding variables recorded by QC appeared to comply with the applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 006 located on BK13-001. Welder is identified as 203805. ZPMC Quality Control (QC) is identified as Liu Fawen. The welding variables recorded by QC appeared to comply with the applicable WPS.

Bay 11

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 031 located on BK012A2-001. Welder is identified as 205649. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 024 located on BK012ASD1-001. Welder is identified as 069866. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09495.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK012A6-001-001, 002, 165, 007

BK012A8-001-001, 002, 130, 007

3003TR2-001-030, 029, 024, 018, 020, 025, 031, 032, 019, 021, 017, 028, 022, 023, 026, 027

3009TR2-001-030, 029, 024, 018, 019, 025, 031, 032, 020, 021, 017, 028, 022, 023, 026, 027

3016TR2-001-003, 004

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09497.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

GGL-MQ-2317-001-001, 002

GGL-MQ-2317-002-001, 002

GGL-MQ-2317-003-001, 002

GGL-MQ-2317-004-001, 002

GGL-MQ-2317-005-001, 002

GGL-MQ-2317-006-001, 002

GGL-MQ-2317-007-001, 002

GGL-MQ-2317-008-001, 002

GGL-MQ-2317-009-001, 002

GGL-MQ-2317-010-001, 002

GGL-MQ-2317-011-001, 002

GGL-MQ-2317-012-001, 002

GGL-MQ-2317-013-001, 002

GGL-MQ-2317-014-001, 002

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09500.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

The members are identified as:

SA6501-001-001
SA6501-001-002
SA6501-001-003
SA6501-001-004
SA6501-001-005
SA6501-001-006
SA6501-001-007
SA6501-001-008

Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09495.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK012A6-001-001, 002, 165, 007
BK012A8-001-001, 002, 130, 007
3003TR2-001-030, 029, 024, 018, 020, 025, 031, 032, 019, 021, 017, 028, 022, 023, 026, 027
3009TR2-001-030, 029, 024, 018, 019, 025, 031, 032, 020, 021, 017, 028, 022, 023, 026, 027
3016TR2-001-003, 004

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09500.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

SA6501-001-001
SA6501-001-002
SA6501-001-003
SA6501-001-004
SA6501-001-005
SA6501-001-006
SA6501-001-007
SA6501-001-008

Ultrasonic Testing Inspection (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09497.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

GGL-MQ-2317-001-001, 002
GGL-MQ-2317-002-001, 002
GGL-MQ-2317-003-001, 002
GGL-MQ-2317-004-001, 002
GGL-MQ-2317-005-001, 002
GGL-MQ-2317-006-001, 002
GGL-MQ-2317-007-001, 002
GGL-MQ-2317-008-001, 002
GGL-MQ-2317-009-001, 002
GGL-MQ-2317-010-001, 002
GGL-MQ-2317-011-001, 002
GGL-MQ-2317-012-001, 002
GGL-MQ-2317-013-001, 002
GGL-MQ-2317-014-001, 002

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt, Scott	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
